Work Order II January-31-13 10:44:			*965	i80*	•					Page 1	.,
Item ID: D227 Revision ID: Item Name: Radiu Start Date: 1/31/	s Block	110.0	Accept	*N9000		100)* s	etup Start Stop	ı VI .	S1* S2*	
Required Date: 2/20/	• /		-	Cust Item II Customer:) :						
Reference:			•					_			
Approvals: Proc	cess Plan: MUゴ	Date: \\3-0\-	3\ Tooling: _	Da	te:		R	tun Start	1/1	R1*	
QC:	•	Date:	SPC (Y/N):	Da	te:			Stop	*N	R2*	
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
Draw Nbr	Revision Nbr										
D2274	Rev F									=	
*100 *100* Shear	SHEAR Memo blanks 9.00)" long +/- 0.030"Note: 1	·	DO 13/02/	14		2%	Ø			
*110 *110* HAAS 1 HAAS CNC vertical machine	HAAS CNC VERTICA Memo ine #1 Machine a	AL MACHINING #1 s per folio D2274	0.00 0.00 FB	13/02/2	; /		296	<u> </u>		• • • • • • • • • • • • • • • • • • •	-
120 *120* oc	QC2- Inspect parts off Memo	machine FAI/FAIB	0.00 0.00 F+	<u> 13/02/</u> ;	2(296	<i>—</i> 9	-	, N. 9	· ·
Quality Control	:vicillo		/ • *	,	,			•			

NCR:	Yes	/ No				WORK ORDER NON-C	100	NFOR	MANCE / UPI	DATE		•		-	
												QA Closed:	Date	e:	
Work Ord	dor.					DISPOSITION				AGAINST	DE	PARTMENT/	PROCESS		
Part NCR	No.					Rework Scrap Use-as-is Work Order Update			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		l	Water Jet d. Eng. Coor. e/Packaging Supplier		Engineering Quality Other
Root					Descri	ption of work order update		Initial	Act	tion		Sign &			
Cause		Date	Step	Qty	(or Non-conformance	Cr	nief Eng	Descr	ription		Date	Verification		QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved										. •					
							AUI	LT CATE	GORY				<u></u>		
Land		1			<u></u>	General	_	٦				1	Г	_	l- <i>1</i>
		Bending Centre N Cracks	ot Concer	ntric to (o/s	Bend BOM/Route Broken/Damaged		Grain Hardwa Inspect	ire ion Incomplete			Ovalized Over/Under Part Incorred	F		Pressure/Forced Temperature/Cure Weld
		Crushed/	Crimped.			Burrs		Instruct	tions Incomplete/l	Unclear		Part Lost/Mi	ssing		Wrong Stock Pulled

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

DQA:

Part Moved

Positioned Wrong

Power Loss/Surge

Other

Date:

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Cuffs

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID 96580 *96580* Page 2 January-31-13 10:44:20 AM D2274 Accept Item ID: Setup Start *N900040100* **Revision ID:** Stop Item Name: Radius Block **Start Qty: 120.00** *120* **Start Date:** 1/31/13 **Cust Item ID:** Req'd Qty: 120.00 Required Date: 2/20/13 *120* **Customer:** Reference: Run Start Process Plan: _____ Date: ____ Tooling: Approvals: Date: Stop Date: _____ SPC (Y/N): Date: Sequence ID/ **Operation** Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. **Work Center ID** Code Qty Qty Number Stamp Description **Run Hours** 130 QC8- Inspect parts - second check 0.00 296 \$ *130* OC 0.00 Memo **Quality Control** 140 0.00 All 761838 Small Fab *140* 0.00 Small Fab Memo Small Fab TumbleDeburr any rough edges after tumbling

0.00

0.00

The 1/6/338

Chemical Conversion Coat per QSI005 4.1

Memo

150

150
HandFinish

Hand Finishing

												DQA:	Da	ite: _	
NCR:	Yes	/ No				WORK ORDER NON-C	10:	VFORM	AANCE / UPD	ATE		_		-	
											QA	Closed:	Da	ate:	
Work Orde	0.00					DISPOSITION	İ			AGAINST D	EPAF	RTMENT/	PROCESS		
Work Orde	ei. <u>–</u>					Rework	1 		Skid-tube	Crosstube	7		Water Jet		Engineering
Part N	No					Scrap			Machining	Small Fab	1	Proc	d. Eng. Coor.	-	Quality
raici	•••					Use-as-is			noforming	Finishing	1		e/Packaging	_	Other
NCR I	No.					Work Order Update			Large Fab	Composite	1	,	Supplier	-	
•	_						,		·						
Root					Descri	ption of work order update	Ī	nitial	Acti	ion	5	Sign &			
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Descri	iption		Date	Verification)n	QC Inspector
Doc/Data															
Equip/Tooling															
Operator	Ш			{	ļ							i			
Material	Ш													}	
Setup 🔥								,							
Other	Ш							•							
Process	Ш														
Supplier											1				
Training	Ш										-				
Unapproved							丄								
						F	<u>AUL</u>	T CATE	GORY						
Landi	$\overline{}$					General		1						_	1
	$\boldsymbol{\vdash}$	Bending				Bend	_	Grain			_	ralized		_	Pressure/Forced
	Щ	Centre No	t Concer	ntric to	o/s	BOM/Route	_	Hardwa			⊣	er/Under		<u> </u>	Temperature/Cure
	\vdash	Cracks				Broken/Damaged	_	1	on Incomplete	<u></u>	-	rt Incorrec			Weld
	\vdash	Crushed/C	Crimped.			Burrs		4	ions Incomplete/U	Inclear	_	rt Lost/Mi	ssing		Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance		Pa	rt Moved			

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Positioned Wrong

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Ord January-31-13		580		*965	8 0 *						Page 3
Item ID: Revision ID: Item Name:	D2274 Radius Block			Accept	*N900	040	100)* s	etup Star Stop	171	S1* S2*
Start Date: Required Date Reference:	1/31/13 :: 2/20/13	Start Qty: 120.00 Req'd Qty: 120.00	*12 *12	= =	Cust Item Customer:			_	Stan		
Approvals:		n:	Date:		· · · · · · · · · · · · · · · · · · ·	oate:		F	Run Star Stop	" 7	R1* R2*
Sequence ID/ Work Center 160 *160* QC Quality Control	ID	Operation Description QC7-Inspect Chemical Co	onversion Coat	Set Up/ Run Hours 0.00 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 *170* Packaging Packaging		ldentify as per dwg & Sto	ck Location:	0.00					B	13/3/1	1/286

180

QC21- Final Inspection - Work Order Release

0.00

120

QC Memo Quality Control 0.00

13/3/12 S

NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE QA Closed: Date: Disposition Rework Skid-tube Crosstube Water Jet Engine	ering
Work Order: DISPOSITION AGAINST DEPARTMENT/PROCESS	
Work Order:	
nework Skid-tube Closstabe Water set Eligine	
	3011C)
	Other
NCR No. Work Order Update Large Fab Composite Supplier	
Root Description of work order update Initial Action Sign &	
Cause Date Step Qty or Non-conformance Chief Eng Description Date Verification QC I	nspector
Doc/Data Doc/Data	
Equip/Tooling Equip/Tooling	
Operator	
Material	
Setup Setup	
Other	
Process	
Supplier	
Training	
Unapproved	
FAULT CATEGORY	
Landing Gear General Bending Bending Bend Grain Ovalized Pressure	/Carcad
	ture/Cure
Centre Not Concentric to O/S BOM/Route Hardware Over/Under tolerance Tempera Cracks Broken/Damaged Inspection Incomplete Part Incorrect Weld	ture/cure
	tock Pulled
Cuffs Contamination Maintenance Part Moved	.ock i uneu

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Positioned Wrong

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

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Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print

January-31-13 10:44:20 AM

Work Order ID:

96580

Parent Item:

D2274

Parent Item Name:

Radius Block

Start Date: 1/31/13

Required Date: 2/20/13

Page 1

Start Qty: 120.00

Required Qty: 120.00

Comments:

IPP H00.05.18Added inspection level 8EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B00750X00.125 6061-T6 Bar .750 x .125		Purchased	No			100	f	100.0000	0.0916	11.570532	Po	_13/0	2/14

 Location
 Loc Oty
 Loc Code

 MAT001
 100

 → 124443
 100

11.6 24.9

NCR: Y	es / No				WORK ORDER NON-C	O	NFORM	MANCE / UPDATE					
				_						QA Closed:	Date	•	
Work Orde	er:	=			DISPOSITION			AGAINST	DE	PARTMENT	PROCESS		-
Part N					Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Crosstube Machining Small Fab noforming Finishing Large Fab Composite		•	Water Jet d. Eng. Coor. e/Packaging Supplier	Engineer Qua Ot	,
Root				Descri	ption of work order update	ı	nitial	Action		Sign &			
Cause	Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Description		Date	Verification	QC Ins	pector
Doc/Data													
Equip/Tooling													
Operator											1		
Material]	-									
Setup													
Other													
Process													
Supplier										<u> </u>			
Training												İ	
Unapproved													
					F	ΑUL	T CATE	GORY					
Landi	ng Gear				General		_			_	_		
	Bending	•			Bend		Grain			Ovalized	L	Pressure/F	orced
	Centre N	ot Conce	ntric to (o/s	BOM/Route		Hardwa	ire		Over/Under	tolerance	Temperatu	re/Cure
	Cracks				Broken/Damaged		Inspect	ion Incomplete		Part Incorre	ct [Weld	
	Crushed	/Crimped			Burrs		nstruct	tions Incomplete/Unclear]Part Lost/M	issing	Wrong Sto	ck Pulled
	Cuffs				Contamination		Mainte	enance		Part Moved	_		

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

DQA:

Positioned Wrong

Power Loss/Surge

Other

Date:

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Countersink

Cut Too Short

Drill Holes

Drawing

Finish Folio

DART AEROSPACE LTD	Work Order:	96580
Description: Radius Block	Part Number:	D2274
Inspection Dwg: D2274 Rev: F		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.257	+0.005 -0.000	, 258	>		FK-04	Vern.
0.750	+/-0.010	,750	7		и	4
0.375	+/-0.010	.375	7		h	h
0.125	+/-0.010	.125	\		n	4
0.750	+/-0.010	5 2 F.	7		h	Þ
0.063	+/-0.010	.063	7		h	Λ.
			<u></u>			
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		nada ayan				
		-				

		1)·A	Prototype Approval:	N/A
Date: 3/02/21	Date:	13/02/23 28	Date:	N/A

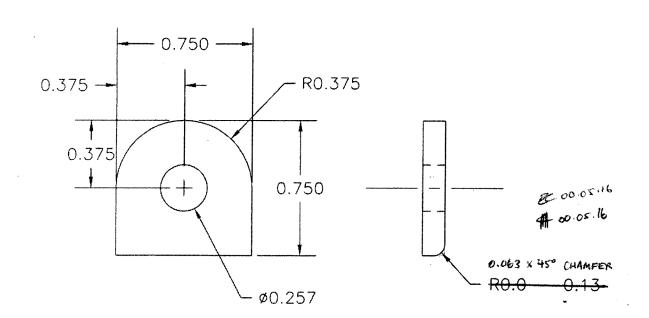
Rev	Date	Change	Revised by Approved
Α_	03.10.07	New Issue	KJ/RF 💸





	DESIG	KE	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
[CHECH	KED /	APPROYED	DRAWING NO. REV. F	
		n W	14	D2274 SHEET 1 OF 1	
	DATE	DATE		TITLE SCALE	
	98.0	98.08.11		RADIUS BLOCK 2:1	
	Ą		94.09.29	NEW ISSUE	
	O		95.07.12	RADIUS ENDS	
	D		97.03.24	ADD MATERIAL SPECIFICATION	
	Ε		97.12.12	ADD FINISH & TOLERANCE QSI	
l	Ė		98.08.11	RO.0 - 0.13 WAS RO.063 - 0.125	





MATERIAL: 5052-H34 (QQ-A-250/8) 0.125 THICK

OR 6061-T6 (QQ-A-250/11) 0.125 THICK

FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED